

July-06-12 2:55:33 PM

Page 1

120	QC2- Inspect parts off machine FAI/FAIB	0.00				
120						
QC	Memo	0.00				
Quality Control						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86803

86803

Page 2

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Item ID: D2850-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: End Cap

Start Date: 7/06/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/24/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: WMA

0.00

140

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL ***

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

6 0

6 0 12/09/11

12/9/13

12/09/12

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Picklist Print

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Page 1

Work Order ID: 86803

Parent Item: D2850-2

Parent Item Name: End Cap

Start Date: 7/06/12

Required Date: 8/24/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B98.12.07Changed folioDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X01.500 6061-T6 Bar 2.50 x 1.50		Purchased	No			110	f	33.2900	0.3208	2.0261052	10	12/09/09	

Location

Loc Qty

Loc Code

MAT004

33.29

16742

33.29

2.03

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	86803
Description: High Float Step End Bracket		Part Number:	D2850-2
Inspection Dwg: D2850	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.55	+/-0.030	3.547	✓		SLOS	Vern
0.189	+/-0.010	.187	✓		↓	
1.720	+0.000/-0.030	1.718	✓		↓	
0.178	+/-0.010	.172	✓		↓	
0.10	+/-0.030	.098	✓		↓	
30°	+/-0.5°	30°	✓		Protractor	
2.15	+/-0.030	2.149	✓		SLOS	Vern
					↓	
0.375	+/-0.010	.370	✓		↓	
0.125	+/-0.010	.117	✓		↓	
1.00	+/-0.030	1.003	✓		Height Gauge	
					SLOS	Vern
0.125	+/-0.010	.127	✓		↓	
0.750	+/-0.010	.750	✓		↓	
R0.25	+/-0.030	R.250	✓		Rad Gauge	
R0.063	+/-0.010	R.063	✓			
Ø0.257	+0.006/-0.001	Ø.259	✓		SLOS	Vern
0.600	+/-0.010	.603	✓		"	

Measured by:	SP
Date:	12/09/10

Audited by:	A.A
Date:	12/09/10

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

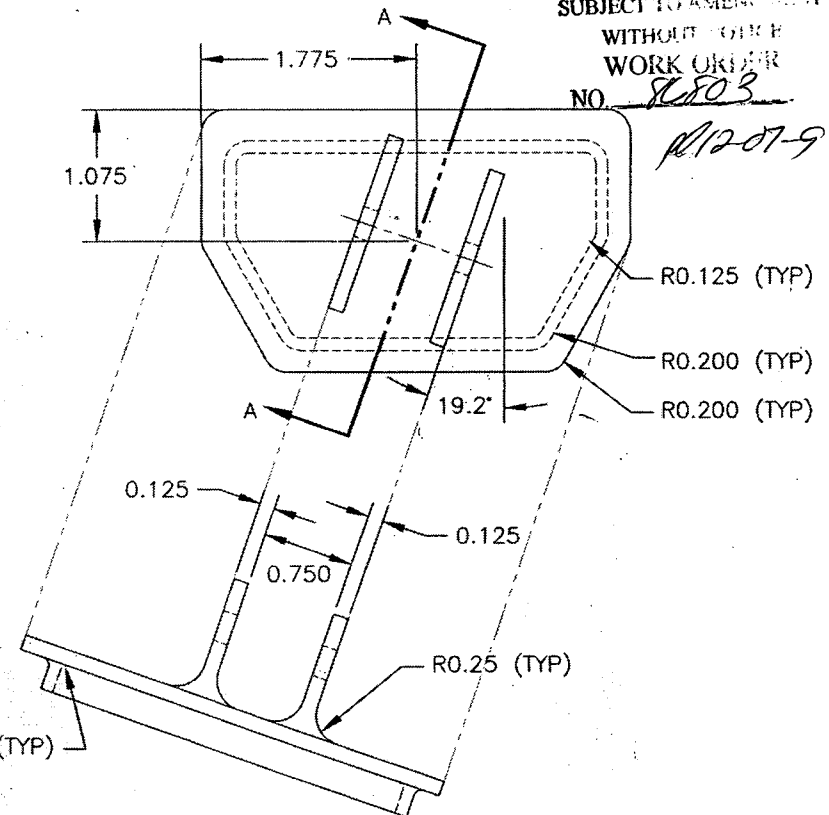
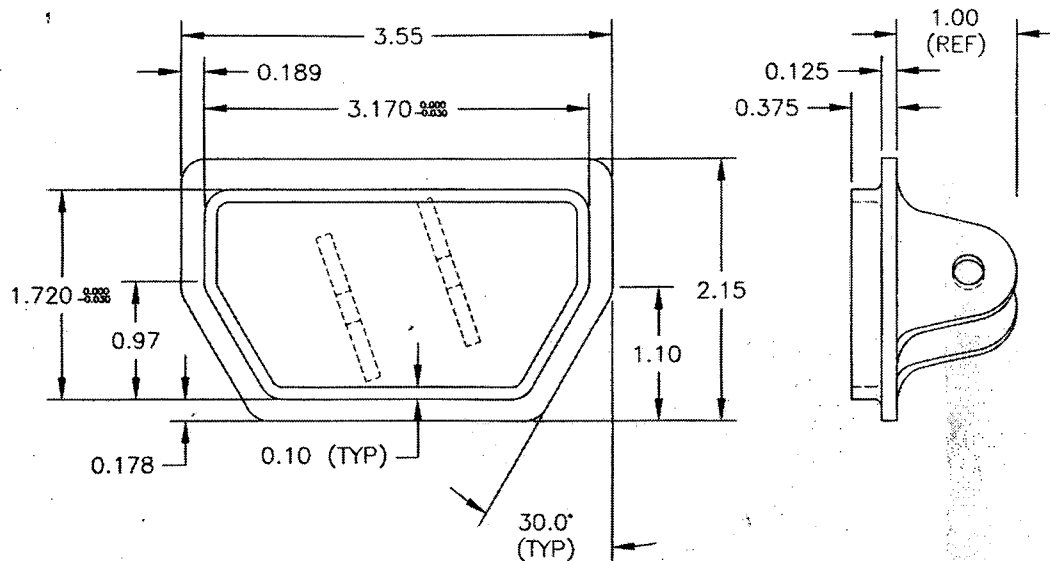
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

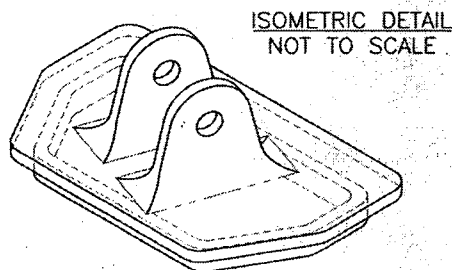
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SHOW ONLY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *82803*

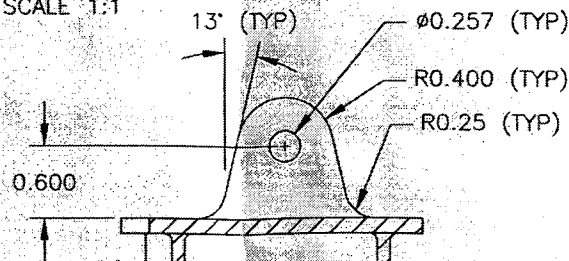


D2850-1 (SHOWN)
D2850-2 (OPPOSITE)
MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: NONE
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



ISOMETRIC DETAIL
NOT TO SCALE

SECTION A-A
SCALE 1:1



RELEASED
98.11.29 KE

A	98.11.10	NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B	
DESIGN <i>OP</i>	DRAWN BY <i>OP</i>	DART DART AEROSPACE LTD WARRICKBURY, OXFORD, ENGLAND	
CHECKED <i>KE</i>	APPROVED <i>#</i>	DRAWING NO. D2850	REV. A SHEET 1 OF 1
DATE 98.11.10	TITLE HIGH FLOAT STEP END BRACKET		SCALE 1:1

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